Page 1

August 6, 2009 2:31:58 PM

Item ID:

D2618

Revision ID: В1

Item Name:

Bushing

Start Date: 8/21/09

Start Qty: **6**0.00 Req'd Qty 60.00

Accept



Setup Start

Stop



Required Date: 8/28/09 Reference:

Approvals:

Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date: Date:

Start Run

Reject

Qty

Stop



Sequence ID/ Work Center ID **Operation** Description Set Up/ **Run Hours** Draw Number

Cust Item ID:

Customer:

Draw Plan Rev. Code

Accept Qty

Reject

Insp. Number Stamp

Draw Nbr

Revision Nbr

Rev B1

D2618

Hardinge CNC Lathe Small

100

Hardinge

Hardinge CNC LATHE SMALL

Memo

0.00 1-Turn as per Folio FA195 & Dwg D2618.1.2-Deburr

0.00

110

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

120

0.00

Quality Control

Memo

QC8- Inspect parts - second check

0.00

Dart Aerospace L

	-									
W/O:		WORK ORDER CHANGES								
DATE	STEP	PRO	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			. 14							
Part No: PAR #:		PAR #:	Fault Cate	gory:	_ NCR	: Yes N	lo DQ /	A :	_ Date: _	
Resolution:			Disposition: Q			QA: N/C Closed: Da			Date:	
NCR:			WORK ORDE	ER NON-CONFORM	ANCE	(NCR)	١			
DATE	STEP	Description of NC	Description of NC Corrective Action		Section B Ve			Verification Approva		Approval
DAIL	SILF	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Secti	on C	Chief Eng	QC Inspector
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NOTE: Date & initial all entries

August 6, 2009 2:31:58 PM

Item ID:

Revision ID:

D2618

Bushing

B1

Item Name:

Start Date:

8/21/09

Required Date: 8/28/09

Start Qty: 60.00 Req'd Qty: 60.00



Accept

Setup Start

Stop



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

QC: _____

Date:

SPC (Y/N):

Tooling:

Set Up/

Run Hours

Date: Date:

Start Run

Stop



Sequence ID/ **Work Center ID**

130

Packaging

Operation Description

Identify as per dwg & Stock Location: 39

QC21- Final Inspection - Work Order Release

Date:

0.00

Draw Number

Draw Rev.

Plan Code

Accept Qty

Reject Qty

Reject Insp. Number Stamp

Memo Packaging

0.00

140

Quality Control

Memo

0.00

0.00

Dart Aerospace L	Lta
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W/O:	W/O: WORK ORDER CHANGES								
DATE	DATE STEP PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
					·				
							1		
									•
						<u>y</u>			
Part No	:	PAR #:	Fault Cate	gory: N	CR: Yes	No DQ	A:	Date: _	<u> </u>
_	R	esolution:	Dispositio	n: Q	A: N/C C	closed:		Date: _	
NCR:			WORK ORDI	ER NON-CONFORMANO	E (NC	R)			
DATE	STEP	Description of NC Section A	Initial	Corrective Action Section B Action Description	Sign	& Secti	cation on C	Approval Chief Eng	Approval QC Inspector
	-		Chief Eng	Chief Eng	Date	3	······································		į
								,	

NOTE: Date & initial all entries

Picklist Print

August 6, 2009 2:31:57 PM

Work Order ID: 51189

Parent Item:

D2618RevB1

Parent Item Name: Bushing

Comments:

Component Item ID/	Replacement	Mfg/
Item Name	Item ID	Purch

MDELRINR0.750

Purchased



Delrin Round Bar 0.75"



Start Date: 8/21/09

Required Date: 8/28/09

Start Qty: 60.00

Required Qty: 60.00

Bin Item	Primary Location	Last Location	Route Seq ID			Remaining Qty To Pick	~ .	Date Issued	Status
No			100	f	68.4200	16.2947			

Warehouse	Loc Qty	Loc Code	
Location			
Main Warehouse			
MAT	68.42		
109183	1.84		
110062	66 59		

M 112 480 SN 0408/26 + Ly 5fT

Dart	Aerospace	e Ltd
W/O:		

W/O:			WORK ORDER CHANGES							
DATE STEP		PR	OCEDURE CHANGE	Ву	By Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspector		
·										
Part No	:	PAR #:	Fault Category:	NCR: Ye	s No DQ	A:	Date: _			
	Resolution:		Disposition:	QA: N/C	Closed:		Date:			

NCR: WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B			Approval Chief Eng	
DATE	STEP	Section A	Initial Action Description Sign & Chief Eng Chief Eng Date		Verification Section C	Approval QC Inspector		
* * name								

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	31169
Description: Bushing	Part Number:	D2618
Inspection Dwg: D2618 Rev: B1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.100	+/-0.010	3.103	/			
Ø0.500	+0.000/-0.010	0,495	/			
Ø0.313	+0.020/-0.000	3,103 0,495 0.321	/			
		4.00				
						
	1					

Measured by:	Audited by:	b.A	,	Prototype Approval:	N/A
Date: 8/08/26	Date:	09/08	29	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	04.08.26	New Issue	KJ/JLM ,	
В	04.09.10	Changed tolerance for Ø0.500	KJ/JLM	

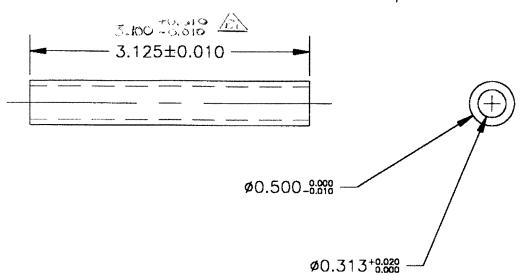




DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. 8
BL	Bu	D2618 SHEET	1 OF 1
DATE	······································	TILE	SCALE
96:10:30		BUSHING	1:1
В	, 97.05.09	3.125 WAS 1.625, .313 WAS .375	
S. 1/2 4	- 6. 6	PROMES ON THE STATE OF THE	

RELEASED (1) (1) (1) (1) (1)

W/O 5/189



MATERIAL: DELRIN OR TEFLON OR NYLON